



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE117-68021W5-1
Job Sheet 185131



Part No: RBE117-68021W5-1

Job Qty: 8 ea

Part Name: Plate



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/23/18

Job Tracking No:

Due Date: 11/23/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE117-68021W5 Rev. 1 IPP Rev. A 18.09.28 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	11/23/18	11/23/18	0.00	0.00	Start Up Machining-3		18-12-04 PJ
120	CNC Lathe	8 pcs	11/23/18	11/23/18	0.00	4.00	MORI NV5000-1		18-12-04 PJ
130	QC	8 pcs	11/23/18	11/23/18	0.00	0.00	QC2 Machining-4		18-12-04 PJ
140	QC	8 pcs	11/23/18	11/23/18	0.00	0.00	QC8 Machining-4		18-12-04 PJ
170	Outsource	8 pcs	11/23/18	11/23/18			GRO002-VC	10	18-12-04
180	Packaging	8 pcs	11/23/18	11/23/18	0.00	0.00	Packaging2		DEC 18 2018
190	QC	8 pcs	11/23/18	11/23/18	0.00	0.00	QC6		38
200	Packaging	8 pcs	11/23/18	11/23/18	0.00	0.00	Packaging3-1		9-89
210	QC21-SA	8 Ea	11/23/18	11/23/18	0.00	0.00	QC21		DEC 19 2018

Part Op 120 - 1-Machine as per DWG. FC427 FOLIO REV: AA DWG REV: 1 2-Deburr 3- Use DT10447
Descriptions: soft jaws

170 - Issue P/O to GROUPE ALTECH; PO 041986 -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
Mt-4140-S-1.500X3.000	4140 Steel Bar 1.500 X 3.000	3.3360 ft (.417 ea)	90-Start up Operation	5088719-4PCS
				345230-4PCS

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	Mt-4140-S-1.500X3.000	3	7	0

Part Specifications

could not be found.

Plex 10/23/18 8:54 AM Dart.lajeunesse.marie



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S134623



Part: RBE117-68021W5-1

Job No: 185131

Serial No/Batch: S134623

Revision: 1

Inspector:

Exp Date:

Instructions:

Date: 12/04/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

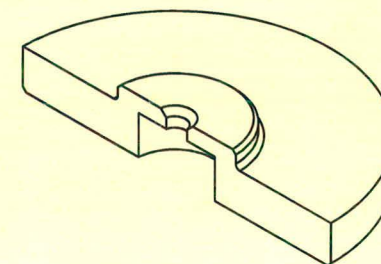
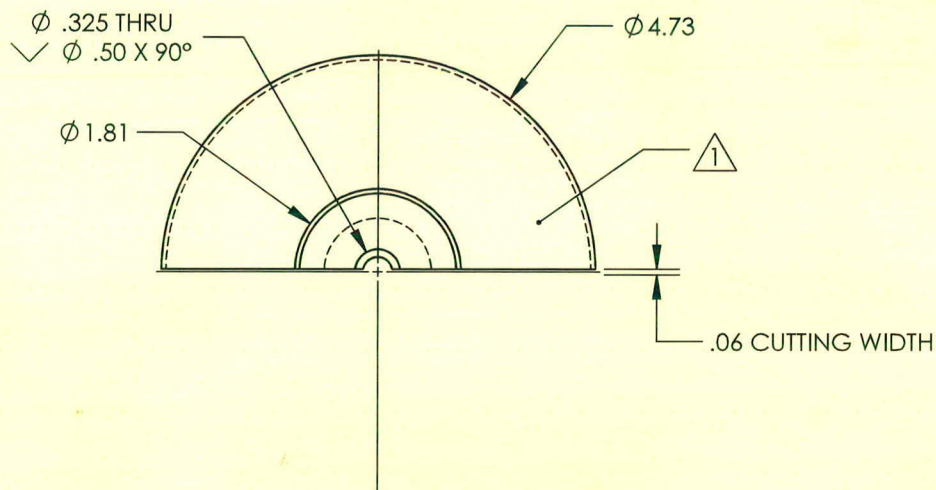
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
				OTHER					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

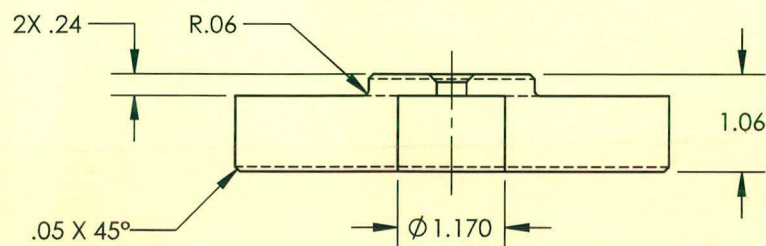
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REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 185131 MLC5
187023



(-1)
PLATE

NOTE:

① ENGRAVE T/N, S/N, "MADE IN USA" ON FIRST PART, ENGRAVE T/N ON SECOND PART.

DART AEROSPACE	
TITLE MOUNT	
DWG NO. RBE117-68021W5-1	REV 1
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT RC 28-34	.XXX ± .005 FRACTIONS ± 1/8
FINISH BLACK OXIDE	.XX ± .01 ANGLES ± 5°
SPEC QMSI-6.2.2 REV D	.X ± .1 SURFACES = 125✓
DRAWN BY: MACKOVJAK	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H145
SCALE 1:2	DATE 7/28/2016 SHEET 2 OF 2



Dart Aerospace Ltd.
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Tel (613) 632-5200

PURCHASE ORDER **PO041986**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO041986
PO Date: 12/7/18
Due Date: 12/17/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	186298	RB6872879-3	Counterbore Cutter -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; -Certificate of Conformity is required	Firmed	-	12/17/18	1 pcs	0 pcs	1 pcs	\$5.454545/pcs	\$5.45
2	185122	RBE117-12020-W20-3	Cup -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	12/17/18	4 pcs	0 pcs	4 pcs	\$5.454545/pcs	\$21.82



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PURCHASE ORDER **PO041986**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	185131	RBE117-68021W5-1	Plate -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	12/17/18	8 pcs	0 pcs	8 pcs	\$5.454545/pcs	\$43.64
4	186775	RBT200078-1	Trunnion Bolt (Hex Head Cap Screw) -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; Steel -Certificate of Conformity is required	Firmed	-	12/17/18	4 pcs	0 pcs	4 pcs	\$5.454545/pcs	\$21.82
5	185467	RBE1120-31502W1-9	Pin -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; O1 -Certificate of Conformity is required	Firmed	-	12/17/18	5 pcs	0 pcs	5 pcs	\$5.454545/pcs	\$27.27
Grand Total:											\$120.00

DAS
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9-88

DEC 18 2018

DEC 17 2018

DEC 18 2018



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PURCHASE ORDER PO041986

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 12/12/18 12:31 PM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(015184-3)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

015184 - 3

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
13-Dec-2018		Aman		041986				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
2	RBE117-12020-W20-3 Rev. ✓	RBE117-12020-W20-3 01-OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL MIL-PRF-16173 GRADE 3 CLASS 1 WIPE OFF EXCESS	OXIDE-BLACK CH	4	4 ✓	0	0	0
3	RBE117-68021W5-1 Rev. ✓	RBE117-68021W5-1 01-OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL MIL-PRF-16173 GRADE 3 CLASS 1 WIPE OFF EXCESS	OXIDE-BLACK CH	8	8 ✓	0	0	0
5	RBE1120-31502W1-9 Rev. ✓	RBE1120-31502W1-9 01-OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL MIL-PRF-16173 GRADE 3 CLASS 1 WIPE OFF EXCESS	OXIDE-BLACK CH	5	5 ✓	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness
Inspecteur Qualité
Quality Inspector
Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

